

# Work Order ID 61523



Page 1

August 30, 2010 10:11:28 AM

Item ID: D2858-2

Accept



Setup Start



Revision ID:

Stop



Item Name: Hinge Bracket

Start Date: 30/08/2010 Start Qty: 6.00



Cust Item ID:

Required Date: 08/09/2010 Req'd Qty: 6.00

Customer:

Reference:

*10.08.30*

Run Start



Approvals:

Process Plan:

Date:

Tooling:

Date:

Stop



QC:

Date:

SPC (Y/N):

Date:

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID

Tool #

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

Draw Nbr

Revision Nbr

D2858

Rev B

100

0.00



BAND SAW

*H.A 10/09/13*

*6*

*0*

Bandsaw

Memo

0.00

Jeaspa Bandsaw

Cut blanks 5.850

" Note: 1 Blank Makes 3 Parts

110

0.00



HAAS CNC VERTICAL MACHINING #1

*H.A 10/09/13*

*6*

*0*

HAAS 1

Memo

0.00

HAAS CNC vertical machine #1

1-Machine per folio FA941

FOLIO REV: *B*

DWG REV: *B*

2-Deburr any rough edges

120

0.00



QC2- Inspect parts off machine FAI/FAIB

*H.A 10/09/13*

*6*

*0*

QC

Memo

0.00

Quality Control

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Customer:

Reference:

Run Start



Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Stop



QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID

Tool #

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

130

QC8- Inspect parts - second check

0.00

*LF 10/09/14*

6

0

QC

Memo

0.00

Quality Control

140

Chemical Conversion Coat per QSI005 4.1

0.00

*LF 10-9-14*

6

HandFinish

Memo

0.00

Hand Finishing

150

White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum

0.00

*LF 10-9-21*

6

Powdercoat

Memo

0.00

Powder Coating

START TIME:

*2:00*

OVEN TEMPERATURE:

*320* FINISH TIME:

*2:30*

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Item ID:	D2858-2	Accept		Setup	Start	
Revision ID:					Stop	
Item Name:	Hinge Bracket					
Start Date:	30/08/2010	Start Qty: 6.00		Cust Item ID:		
Required Date:	08/09/2010	Req'd Qty: 6.00		Customer:		
Reference:						

Approvals:	Process Plan:	Date:	Tooling:	Date:	Run	Start	
	QC:	Date:	SPC (Y/N):	Date:		Stop	

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
160  QC Quality Control	QC3- Inspect Part Finish  Memo	0.00 0.00	= 7Ml 10/09/22			6	0		
170  Packaging Packaging	Identify as per dwg & Stock Location: 25  Memo	0.00 0.00	10/9/22						
180  QC Quality Control	QC21- Final Inspection - Work Order Release  Memo	0.00 0.00	10/09/23						

MF  
10-9-22

# Picklist Print

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Work Order ID: 61523

Parent Item: D2858-2

Parent Item Name: Hinge Bracket



Start Date: 30/08/2010

Required Date: 08/09/2010

Start Qty: 6.00

Required Qty: 6.00

Comments: IPP ☐ C ☐ 00.06.22 ☐ Removed P/O for powder coat ☐ EC ☐

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M6061T6B1.500X01.25 0		Purchased	No			110	f	41.1080	0.163	1.029474			



6061-T6 Bar 1.50 x 1.25



Location

MAT10

107461

110936

Loc Qty

41.10795

11.26315

29.8448

Loc Code

HA 10/09/13  
1.0294 ft

<b>DART AEROSPACE LTD</b>		<b>Work Order:</b> 61525
<b>Description:</b> Hinge Bracket		<b>Part Number:</b> D2858-2
<b>Inspection Dwg:</b> D2858	<b>Rev:</b> B	<b>Page 1 of 1</b>

### FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article
 ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø0.171	+0.005/-0.000	Ø0.173	✓		Vern	GA-01
Ø0.400	+0.005/-0.000	Ø0.404	✓		"	"
R0.125	+/-0.010	R0.125	✓		Rad Gage	ref.
0.328	+/-0.010	0.330	✓		Vern	GA-01
0.820	+/-0.005	0.820	✓		"	"
1.476	+/-0.010	1.480	✓		"	"
0.342	+/-0.010	0.344	✓		"	"
0.875	+/-0.010	0.875	✓		"	"
1.56	+/-0.030	1.564	✓		"	"
0.147	+/-0.010	0.145	✓		"	"
0.717	+/-0.010	0.718	✓		H-G	31006
0.697	+/-0.010	0.699	✓		Vern	GA-01
0.229	+/-0.010	0.230	✓		"	"
R0.125	+/-0.010	R0.125	✓		Rad Gage	ref
R0.063	+/-0.010	R0.063	✓		"	"
0.063	+/-0.010	0.064	✓		MIC	GA-03
0.126	+/-0.010	0.125	✓		Vern	GA-01
0.630	+/-0.010	0.630	✓		H-G	31006
R0.354	+/-0.010	R0.354	✓		Rad gage	ref
0.965	+/-0.010	0.968	✓		Vern	GA-01
Ø0.166	+0.005/-0.000	Ø0.168	✓		"	"

<b>Measured by:</b> S.A	<b>Audited by:</b> [Signature]	<b>Prototype Approval:</b>	N/A
<b>Date:</b> 10/09/13	<b>Date:</b> 10/09/14	<b>Date:</b>	N/A

Rev	Date	Change	Revised by	Approved
A	04.11.11	New Issue	KJJ/JLM	[Signature]

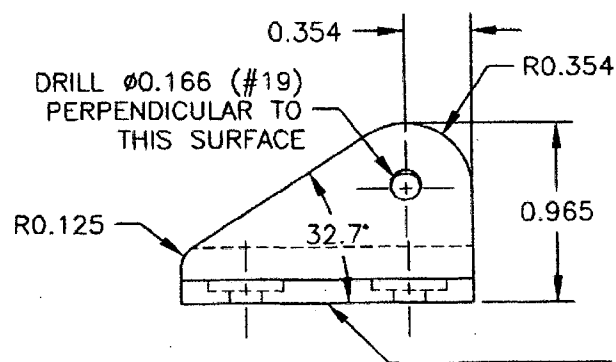
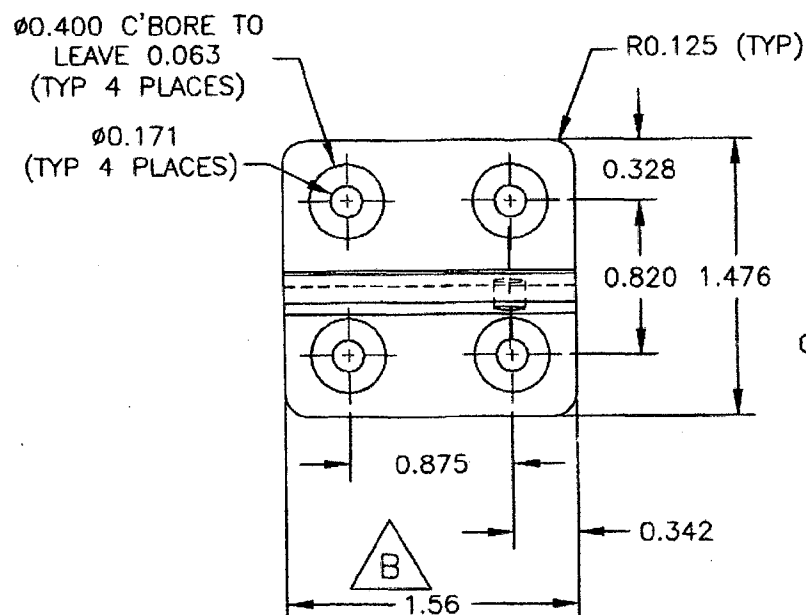
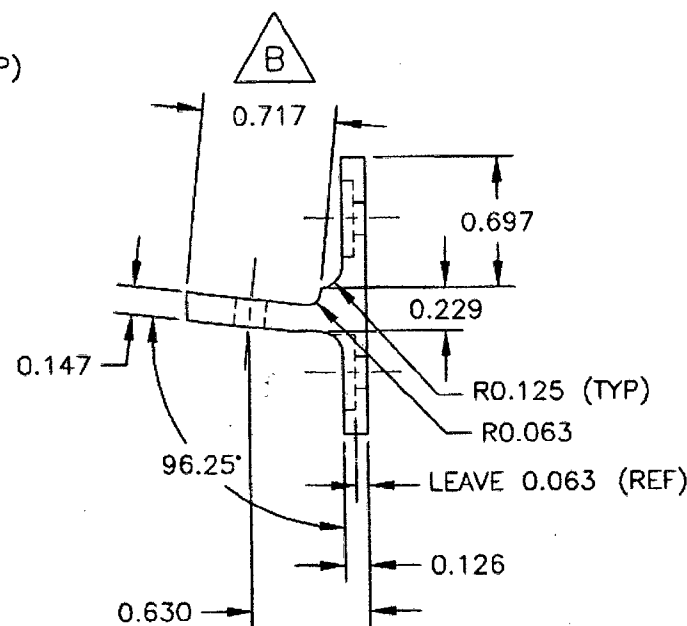
**DART**



RELEASED  
99.03.09 KE

DESIGN	DRAWN BY	DART AEROSPACE LTD	REV. B
11E	11E	HAWKESBURY, ONTARIO, CANADA	
CHECKED	APPROVED	DRAWING NO.	SHEET 1 OF 1
UP	11E	D2858	
DATE	TITLE	SCALE	
99.02.28	HINGE BRACKET	1:1	
A	98.12.14	NEW ISSUE	
B	99.02.28	0.717 WAS 0.667, 1.56 WAS 1.559	

w/o 61525



ENGRAVE P/N CENTERED ON  
BASE 0.003 DEEP (0.010 MAX)

D2858-1 SHOWN  
D2858-2 OPPOSITE

MATERIAL: 6061-T6 ALUMINUM (QQ-A-250/11) OR (QQ-A-200/8) OR (QQ-A-225/8)  
FINISH: ACID ETCH AND ALODINE PER DART QSI 005 4.1  
POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3  
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED